

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012648**Date Inspected:** 16-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bonifacio Daquinag Jr.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

## 1) OBG Lift 2W repairs

1) The QAI arrived at the ABF facilities at Pier 7 to observe repairs of components on OBG L2W. The QAI observed ABF personnel repairing a damaged section of the OBG Lift 2W. The QAI noted that the original plate has been cut out and the 675mm tall x 530mm wide replacement plate is being spliced into longitudinal connection plate, line W3, panel point 13. The QAI noted that the repair is being performed with repair procedure specification (ABF weld repair report #201002-001, dated 2-15-2010). The QAI noted that the Quality Control (QC) Inspector Bonifacio Daquinag Jr is monitoring the repair welding in progress. The QAI was informed that shielded metal arc welding (SMAW) with 1/8" E7018 electrodes will be used with Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A-1 for the fillet welds and ABF-WPS-D15-1010 for the complete joint penetration (CJP) splice welds. The QAI noted that Al McDaniel, ID 2690, is making the repair welds. The QAI made random observations of welding parameters and preheat temperature which were noted as 120 DC amps and a minimum temperature of 70°F. The QAI noted that the work in progress appeared to be generally conforming to the contract and repair specifications. The QAI noted that the welding was in progress at the end of the work shift and the repair was approximately 90% complete.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control

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Plan (WQCP) and approved revisions to the WQCP for the remainder of the work shift. The QAI was also informed that ABF welder Al McDaniel, ID 2690, has been informally approved by the Engineer for SMAW process welding. The QAI was informed that the welder's qualifications have been provided to the Engineer and will be formally listed the ABF WQCP addenda, submittal 1106 revision 18.

### Summary of Conversations:

As noted above, the QAI had conversations with the QC Inspector regarding the repair welding. There were also general conversations regarding the status of the work in progress. The QAI relayed the observations of OBG repair welding QAIs Bill Levell and Joselito Lizardo. Also as noted above, the QAI was informed that welder Al McDaniel's qualifications have been informally accepted. There were no other notable observations or conversations during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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